

Work Order ID 83367

83367

Page 1

April-17-12 2:23:49 PM

Item ID: D3912-5

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Eyebolt Plate

Stop ***NS2***

Start Date: 17/04/2012 Start Qty: 12.00

12

Cust Item ID:

Required Date: 01/05/2012 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/04/12 Tooling:

Date:

Run Start ***NR1***

QC:

Date: SPC (Y/N):

Date:

Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| Draw Nbr | Revision Nbr | | | | | | | | |
| D3912 | B | | | | | (12) | | | |

100

0.00

100

Waterjet

Memo

0.00

FLOW CNC Waterjet

Cut as per dwg D3912

304 .125

Prog Rev: B

Dwg Rev: B

Deburr as required

B12-4-22

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

B12-4-22

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

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Page 2

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N900040100

Setup Start ***NS1***

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Stop ***NS2***

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Start Date: 17/04/2012 Start Qty: 12.00

12

Cust Item ID:

Required Date: 01/05/2012 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

5.714/23

718

Quality Control

130

Identify as per dwg & Stock Location: 10

0.00

130

Packaging

Memo

0.00

180 12/4/23

Packaging

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

12/4/23

Quality Control

12-04-23

| W/O: | | WORK ORDER CHANGES | | | | | |
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NOTE: Date & initial all entries

Picklist Print

April-17-12 2:23:53 PM

Page 1

Work Order ID: 83367

83367

Parent Item: D3912-5

D3912-5

Parent Item Name: Eyebolt Plate

Start Date: 17/04/2012

Required Date: 01/05/2012

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP RevA: new issue DD 09.11.17 verified by:EC

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| M304S11GA | | Purchased | No | | | 100 | sf | 72.0900 | 0.05125 | 0.647368 | 1, | | |

M304S11GA

**

R 12-4-20

304/316 0.125 Sheet

Location

Loc Qty

Loc Code

MAT020

72.09

121070

5.59

121380

66.5

21380

(18)

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NOTE: Date & initial all entries

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
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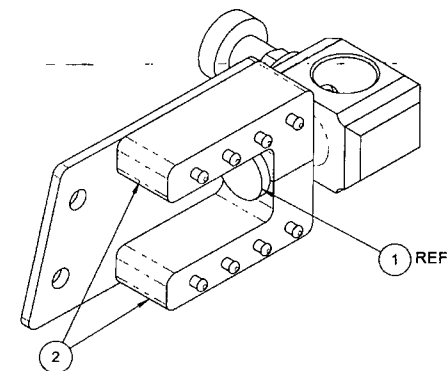
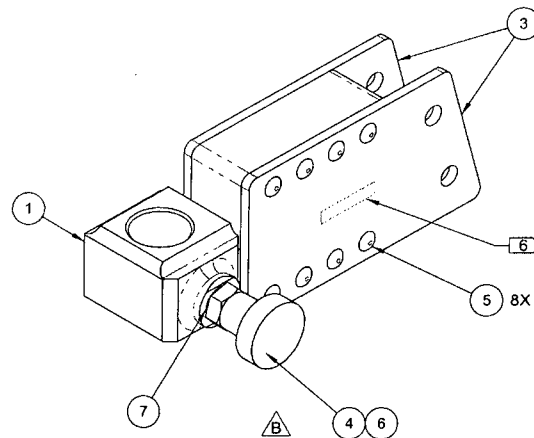
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NOTE: Date & initial all entries

| ITEM | QTY -041 | P/N | DESCRIPTION |
|------|-------------|---------------|-----------------------|
| | X | D3912-041 | EYEBOLT RECEIVER ASSY |
| 1 | 1 | D3912-1 | EYEBOLT |
| 2 | 2 | D3912-3 | EYEBOLT BLOCK |
| 3 | 2 | D3912-5 | EYEBOLT PLATE |
| 4 | 1 | D3801-1 | SPRING PLUNGER |
| 5 | 8 | MS20615-4M20 | RIVET |
| 6 | 1 | MS21209-F615 | HELICAL |
| 7 | 1 | NAS1149F0332P | WASHER |



SUPPLEMENTAL ISO VIEW
(EYEBOLT PLATE REMOVED
TO SHOW INTERIOR FEATURES)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 83367 MLW
12/04/17

RELEASED
2010-07-16

D3912-041 EYEBOLT RECEIVER ASSY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N D3912-041 USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT -041: 1.58 lbs

| | | | |
|------------|--|--|--------------|
| B | D3801-1 WAS D3810-1 SPRING PLUNGER; D4028-041 RMV; MS21209-F615 WAS MS21209-C610 HELICAL; (1) WASHER NAS1149C0663R ADDED; BOSS ADDED TO D3912-1. | JPH | 10.06.28 |
| A | NEW ISSUE | JPH | 10.03.04 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | ALS | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | JS | | |
| CHECKED | JS | DRAWING NO. | REV. B |
| MFG. APPR. | JS | D3912 | SHEET 1 OF 3 |
| APPROVED | JS | TITLE | SCALE |
| DE APPR. | JS | EYEBOLT RECEIVER ASSY NTS | |
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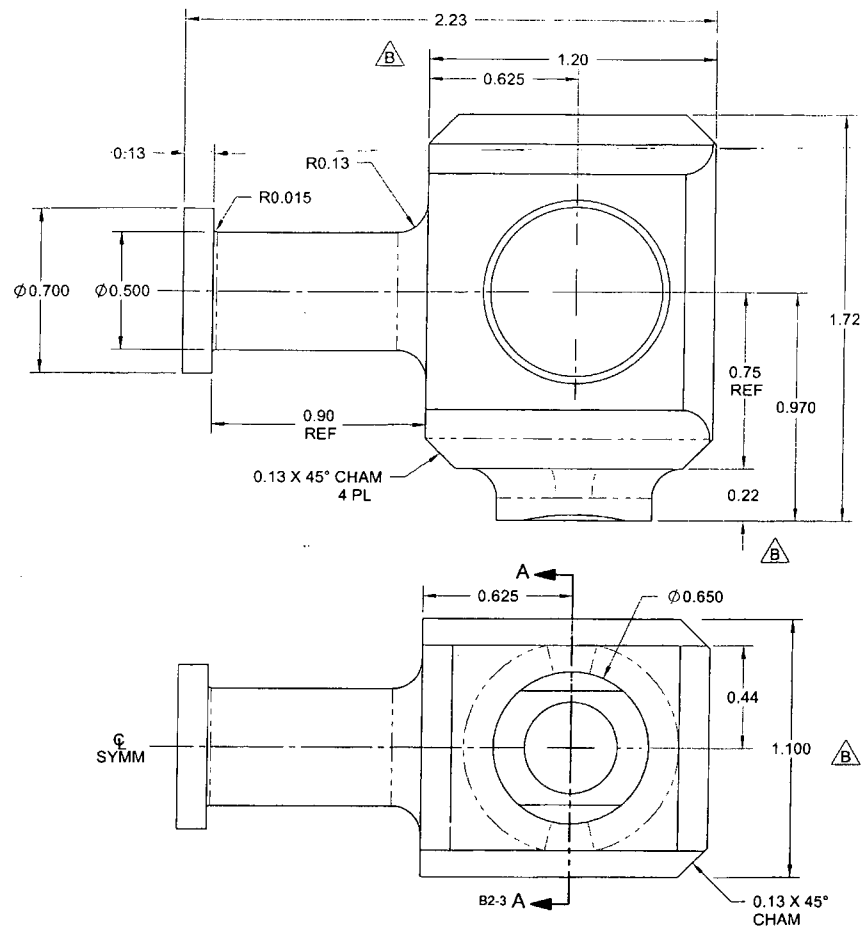
| W/O: | | WORK ORDER CHANGES | | | | | |
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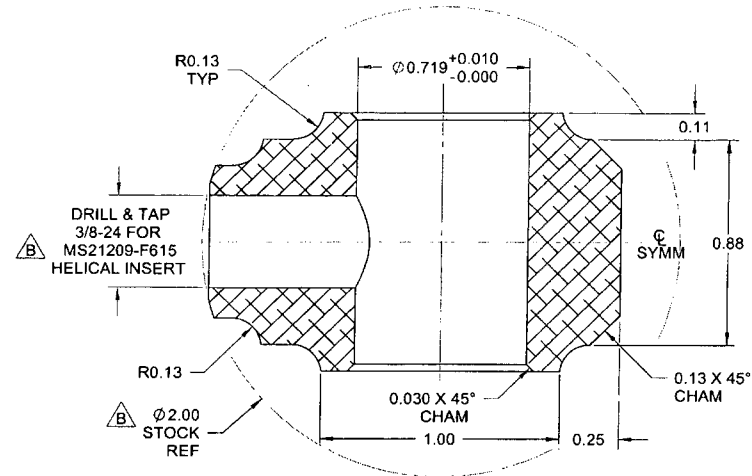
NOTE: Date & initial all entries



D3912-1 EYEBOLT

NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL ROUND BAR, PER ASTM A276 OR ASTM A582
REF DART SPEC M303R OR M304R
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ID AT ASSEMBLY
- 7) WEIGHT: 0.45 lbs



SECTION A-A B6-3

RELEASED
2010-07-16

| | | | |
|--|----------|--|--------------|
| DESIGN | 1.5 | DART AEROSPACE LTD | |
| DRAWN | | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | | DRAWING NO. | REV. B |
| MFG. APPR. | | D3912 | SHEET 2 OF 3 |
| APPROVED | | TITLE | SCALE |
| DE APPR. | | EYEBOLT RECEIVER ASSY | NTS |
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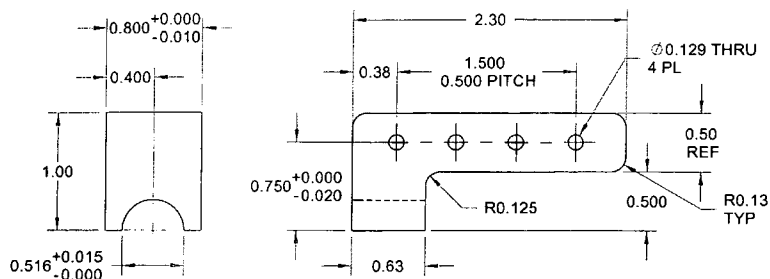
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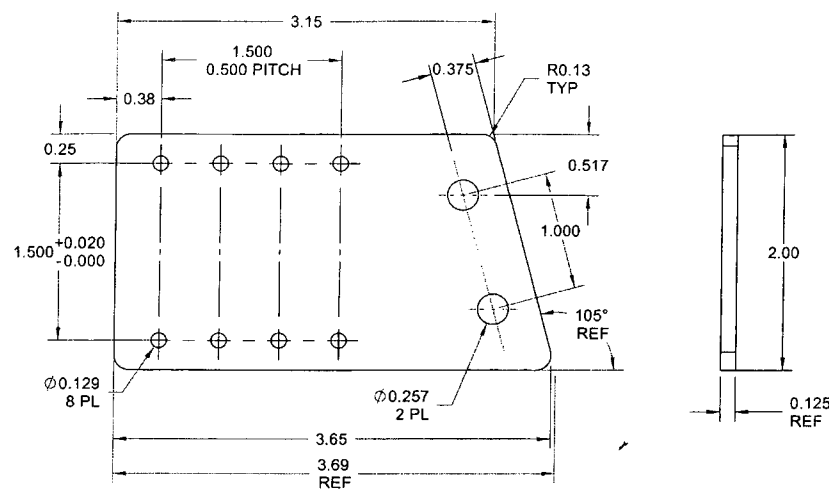
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NOTE: Date & initial all entries

g3367



D3912-3 EYEBOLT BLOCK



D3912-5 EYEBOLT PLATE

RELEASED
2010-07-16

NOTES:

- 1) MATERIAL -3: 303/304/316 STAINLESS STEEL BAR, PER ASTM A276
REF DART SPEC M303B OR M304B
- 5: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B, 0.125 THK
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME 5A240
REF DART SPEC M303S11GA OR M304S11GA

- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ID AT ASSEMBLY
- 7) WEIGHT -3: 0.30 lbs
-5: 0.24 lbs

| | | | |
|------------|----------|--|--------------|
| DESIGN | ASS | DART AEROSPACE LTD | |
| DRAWN | | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | | DRAWING NO. | REV. B |
| MFG. APPR. | | D3912 | SHEET 3 OF 3 |
| APPROVED | | TITLE | SCALE |
| DE APPR. | | EYEBOLT RECEIVER ASSY | NTS |
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